

AIRBUS



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D350-591-312
Job Sheet 173607



Part No: D350-591 2

Job Qty: 10 ea

Part Name: Heli-Acces Step™ RH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/5/18

Job Tracking No:

Due Date: 7/20/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3572-1 JLM IPP Rev:C 08-04-02 ECN1163 DD verified by:EC IPP Rev:D 08-04-08 ECN1164 DD verified by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	7/18/18	7/18/18	0.00	0.00	Start Up Large Fab-4		SLH
110	Large Fab	10 pcs	7/19/18	7/19/18	0.00	10.00	Large Fab 2		SLH
120	QC	10 pcs	7/19/18	7/19/18	0.00	0.00	QC9		CPC
130	QC	10 pcs	7/19/18	7/19/18	0.00	0.00	QC5		CPC
140	HandFinish	10 pcs	7/19/18	7/19/18	0.00	1.87	HandFinish1		SA 18-09-18
150	QC	10 pcs	7/19/18	7/19/18	0.00	0.00	QC7-2		38
180	Large Fab	10 pcs	7/19/18	7/19/18	0.00	10.00	Large Fab 2		DAS 38 SLH
190	QC	10 pcs	7/19/18	7/19/18	0.00	0.00	QC10		38 DAS
200	QC	10 pcs	7/19/18	7/19/18	0.00	0.00	QC5		9-89 38
210	HandFinish	10 pcs	7/19/18	7/19/18	0.00	1.87	HandFinish1		DR 18/09/20
220	Powdercoat	10 pcs	7/19/18	7/19/18	0.00	2.98	Powdercoat1		BR 18-9-25
230	HandFinish	10 pcs	7/20/18	7/20/18	0.00	1.87	HandFinish3		BR 18-09-28
240	QC	10 pcs	7/20/18	7/20/18	0.00	0.00	QC3		SEP 27 2018 68
250	Packaging	10 pcs	7/20/18	7/20/18	0.00	0.00	Packaging1-3		OCT 02 2018 9-89
260	QC	10 pcs	7/20/18	7/20/18	0.00	0.00	QC4		BB 69 OCT 03 2018
265	DC	10 pcs	7/20/18	7/20/18	0.00	0.00	DC		9-89
270	Packaging	10 pcs	7/20/18	7/20/18	0.00	0.00	Packaging3-1		BB DAS OCT 03 2018
280	QC21-FG	10 Ea	7/20/18	7/20/18	0.00	0.00	QC21		69 21 OCT 03 2018

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT10115, weld Fwd End Plate as per QSI 004 & Dwg Descriptions: D3272 A/R Aluminum Rod 136795 3-Grind End Plate flush

180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod 6-Grind End Plate flush 7-Install last rivet as per Dwg.

220 - START TIME: 3:45 OVEN TEMPERATURE: 350 FINISH TIME: 4:15.

265 - Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

270 - Identify and pack for shipping as per PPPD350-591-312 Location : FG072

005707

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	16 20 Ea (2 ea)	90-Start up Operation	5104284
D3219-1	Plate	16 20 Ea (2 ea)	90-Start up Operation	5108646
D3272-1	Step	10 Ea (1 ea)	90-Start up Operation	5074069
D3065-041	Step Leg Assembly	8 10 Ea (1 ea)	180-Large Fab	5109745 / 5110595
D3066-1	Spacer	16 20 Ea (2 ea)	180-Large Fab	5168799
MS20600-AD4W4	Rivet	128 160 Ea (16 ea)	180-Large Fab	5059529 / 5106978
AN3-35A	Bolt	16 20 Ea (2 ea)	250-Packaging	5101329
AN4-13A	Bolt	64 80 Ea (8 ea)	250-Packaging	5089302
AN5-36A	Bolt	16 20 Ea (2 ea)	250-Packaging	5099504
D2230-3	Mounting Lug	32 40 Ea (4 ea)	250-Packaging	5104786 x 28 5110581 x 4
D2618	Bushing	16 20 Ea (2 ea)	250-Packaging	5089996
D2856-400	Abrasion Strip 4" Wide (Per Foot)	16 12 Ea (1.2 ea)	250-Packaging	5104552
D3235-1	Mounting Lug	16 20 Ea (2 ea)	250-Packaging	5113205
D3278-041	Support Assembly	8 10 Ea (1 ea)	250-Packaging	5119310
MS21042L3	Nut	16 20 Ea (2 ea)	250-Packaging	5094592
MS21042L4	Nut	64 80 Ea (8 ea)	250-Packaging	5094597
MS21042L5	Nut	16 20 Ea (2 ea)	250-Packaging	5083541
NAS1149D0363J	Washer	32 40 Ea (4 ea)	250-Packaging	5095293
NAS1149D0463J	Washer	128 160 Ea (16 ea)	250-Packaging	5089299
NAS1149D0563J	Washer	32 40 Ea (4 ea)	250-Packaging	5093773

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3067-1	20	41	0
	D3219-1	20	55	0
	D3272-1	10	0	0
180-Large Fab	D3065-041	10	22	0
	D3066-1	20	10	0
	MS20600-AD4W4	160	1,681	0
250-Packaging	AN3-35A	20	312	0
	AN4-13A	80	941	0
	AN5-36A	20	148	0
	D2230-3	40	65	0
	D2618	20	214	0
	D2856-400	12	72	0
	D3235-1	20	6	0
	D3278-041	10	7	0
	MS21042L3	20	3,284	0
	MS21042L4	80	3,884	0
	MS21042L5	20	849	0
	NAS1149D0363J	40	3,378	0
	NAS1149D0463J	160	5,081	0
	NAS1149D0563J	40	1,290	0

Part Specifications

Specifications could not be found.

Plex 3/5/18 4:02 PM Dart.Gagnon.Michelle

5531

D3065 - 641
5109745

Qty: 7



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Container No: S109756



Part: D350-591-312

Job No: 173607

Serial No/Batch: S109756

Revision:

Inspector:

Exp Date:

Instructions: TC STC SH92-6 Issue 1d FAA STC SH967NE 04/12/21, BRAZIL 1

Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	<i>Heli-Access-Step™</i> , Short Step – High Skid, LH
	X					D350-591-214	<i>Heli-Access-Step™</i> , Short Step – High Skid, RH
		X				D350-591-215	<i>Heli-Access-Step™</i> , Short Step – Low Skid, LH
			X			D350-591-216	<i>Heli-Access-Step™</i> , Short Step – Low Skid, RH
				X		D350-591-311	<i>Heli-Access-Step™</i> , Long Step – High Skid, LH
					X	D350-591-312	<i>Heli-Access-Step™</i> , Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.